

Date: Monday, 14/04/2008 1:07:32 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKID TUBE ASSEMBLY
Job Number :	38588A	Part Number :	D205634041
Estimate Number :	10023	Drawing Number :	D2580 REV D
P.O. Number :		Project Number :	N/A
This Issue :	14/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	D
First Issue :	//	Material :	
Previous Run :	38587A	Due Date :	30/04/2008
Written By :		Qty:	1 Um: Each
Checked & Approved By :	JLD 08.4.14		
Comment :	Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev: O 06.02.28 Added paperwork EC Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002

JLD
08.4.21

2.0

D25001190

Ext'n -1' Beam Tube 4"

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B-34792 AWM 8-4-17

3.0

D2596

Web, 205 Skidtube

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B-38642 AWM 8-4-18

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Debur ends

3-Acid etch and Alodine tube per QSI 005 4.1

AWM 8-4-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 1:07:32 PM
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38588A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08-04-17

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)
 - 2-Open holes to 0.500" as per Dwg D2580without cutting fluid
 - 3-Countersink holes as per Dwg D2580without cutting fluid
 - 4-Deburr and blow out all chips from inside of tube
 - 5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
- Pick:
- | Qty | Part Number | Description | Batch |
|-----------------------|--------------|--------------|---------|
| A/R | Sikaflex-291 | | 7107397 |
| Sikaflex expire date: | | 10/2008 | |
| Start Time: 7:30 AM | | Date: 8-4-18 | |
| Fin Time: 1:30 AM | | Date: 8-4-22 | |

AWM
8-4-18

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

- 1-Bend as per program D2580.C on CNC Bender and Folio FT009
- 2-Cut tubes as per Dwg. D2580

EL JB 8-4-22

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Deburr ends
- 2-Prepare tube for welding, remove alodine as required.

2T 08 04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38588A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/25

10.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>B33321</i>

BE 08/05/06

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	<i>B33323</i>

BE 08/05/06

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

(P10) →

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m107263

BE 08/05/06

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m107263

BE 08/05/06

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*AWM
8-5-6*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: N/A Fault Category: Prod / Std NCR: Yes No DQA: D Date: 08/05/09
 QA: N/C Closed: D Date: 08/05/12

NCR: <u>38588</u> <u>A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/06	12.8	After employee drilled Pilot hole for He is now ring hole he realized that he had located it the Is in the wrong saddle hole.	<i>[Signature]</i>	Fill small hole with weld and grind flush. AR M107263 Re Drill pilot hole at correct saddle hole.	BE 08/05/06 AWM 8-5-6	<i>[Signature]</i>	<i>[Signature]</i>	08/05/06
		R.e. Human error, wasn't paying attention	<i>[Signature]</i>			<i>[Signature]</i>	<i>[Signature]</i>	08/05/06

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Job Number: 38588A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 08/05/06 (40)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/06 (2)

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

BR 08-05-07

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107550

41 08-05-08

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/05/08

18.0 D2855 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B37570

M. 4

19.0 AN35A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M100188

M. 4

20.0 AN960JD10L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M105442

M104885

M. 4

M. 4 08/03/08

B38588A
D205634041
08/05/2008
S.208 07/54
#1 324.3 F
#2 F
#3 30 F
#4 M.L.U F

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 38588A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	ALS71032130	Insert
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch:

M105819

M. h

22.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch:

M107242

M. h

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch:

M107736

M. h

24.0	D356613	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B32744

M. h

25.0	D35665	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B38647

M. h

26.0	D35661	GASKET
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B38410

M. h

27.0	D356413	WEARSHOE
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B38047

M. h 08/05/08

(1X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 1:07:32 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38588A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D356411	WEARSHOE
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B38548

M. L.

29.0	D35649	WEARSHOE
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B38408

M. L.

30.0	D35645	WEARSHOE
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B38409

M. L.

31.0	D25943	O-Ring
------	--------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch:

B29908

M. L.

32.0	D25941	Plug
------	--------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch:

B37419

M. L.

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M107804

Sikaflex expire date:

08/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

M. L. 08/05/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 38588A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M107804

08/10

M107380

M-2 08/08/08

(1X)

34.0

QC5

INSPECT WORK TO CURRENT STEP



08/05/08

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

H

08/05/08

(1)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/05/08

38588A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>HH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *HH*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

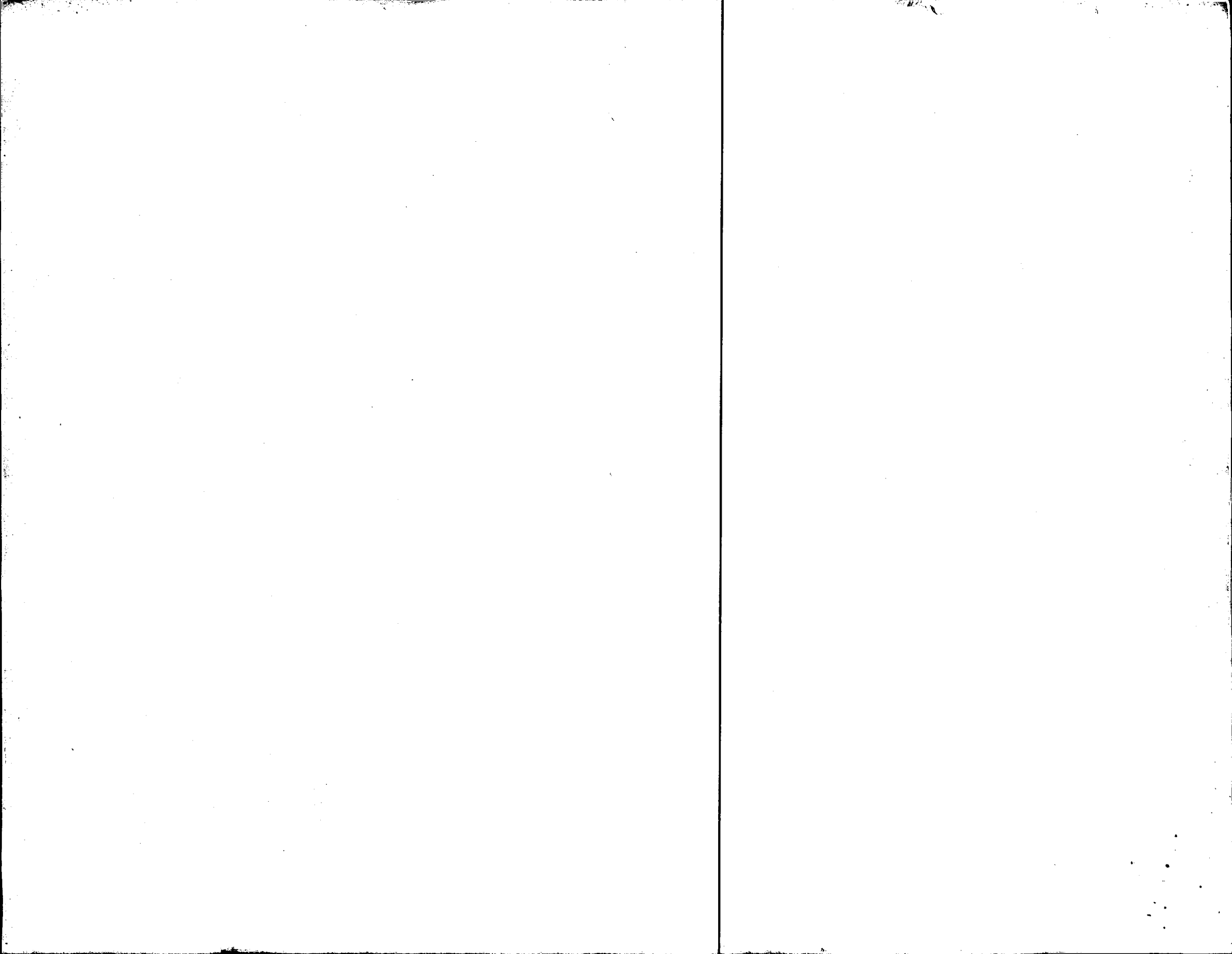
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 388884

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NO. 149

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 383973
Part number: D205 634 041
Description: skid tube 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Duval Date of Test Coupon 08-04-18

Welder Barclay Elliot Date of Test Coupon 08-04-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

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Job Number :	38588		
Estimate Number :	10022		
P.O. Number :		Part Number :	D205634011
This Issue :	14/04/2008	Drawing Number :	N/A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	11	Drawing Revision :	N/A
Previous Run :	38587	Material :	
Written By :		Due Date :	30/04/2008
Checked & Approved By :	JLD 08.4.14		
Comment :	Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Photocopy bluefile & type labels per PPP D205-634-011 CHG005

2.0	38588A	SKID TUBE ASSEMBLY
-----	--------	--------------------



Comment: Sub-Component SKID TUBE ASSEMBLY
 D205-634-041 B

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	K10003	Saddle, D205-634-011
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 38588

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-05-08

W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D2968-041	TOW RING
41	1	1				AN970-4	WASHER
43	1	1				MS21042L4	NUT (OR MS21042-4)
50					1	D2736-1	GHW LUG
51					1	D2736-3	GHW LUG
52					4	AN4-46A	BOLT
53					8	D2570	BUSHING
54					4	MS21042L4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

SHOP COPY

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

RETURN TO

ENGINEERING

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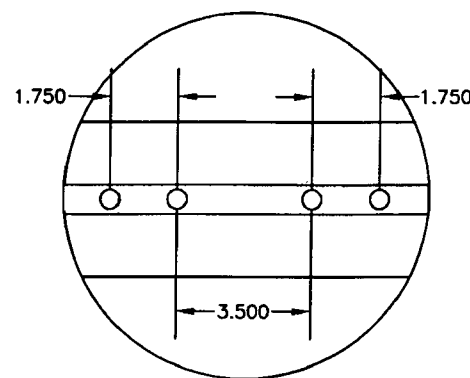
WORK ORDER

NO. 38588

Revision: D

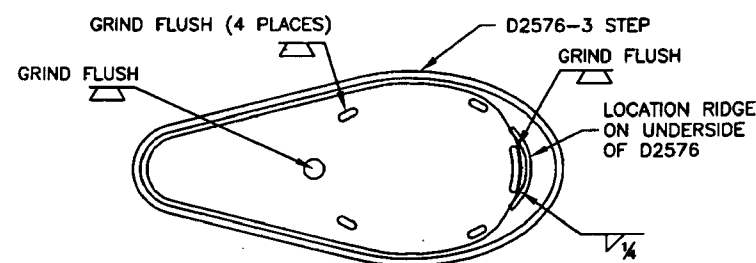
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DETAIL A
SCALE 5:24

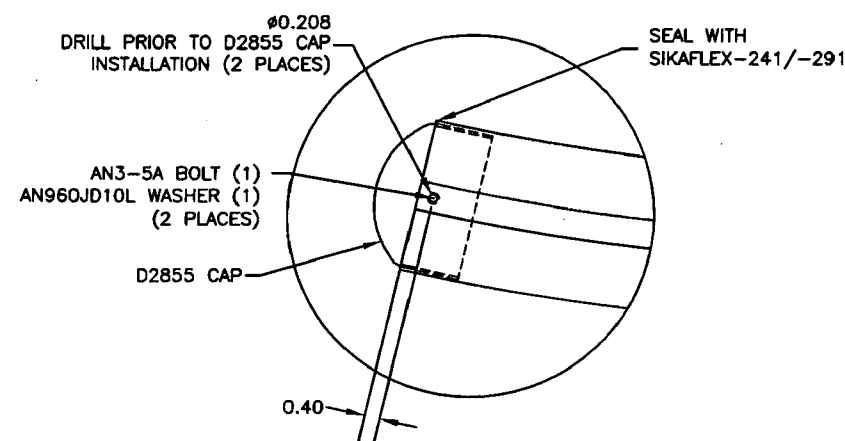


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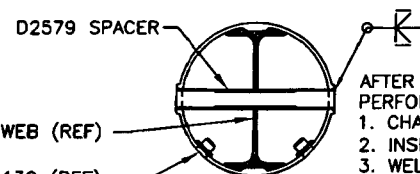
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

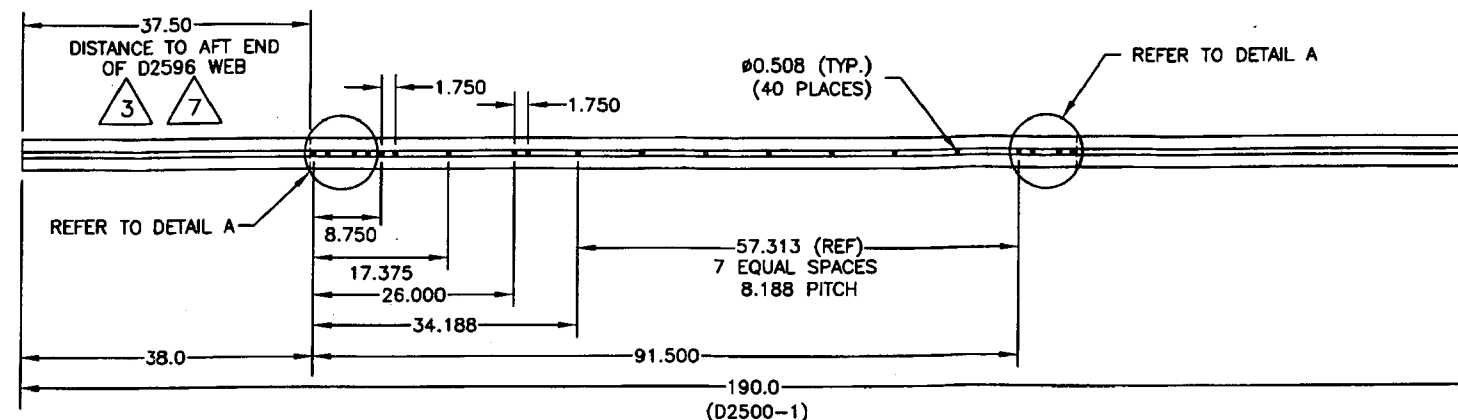
WORK ORDER NO. 385884

ALS7-1032-130 (REF)
(TYP 50 PLACES)

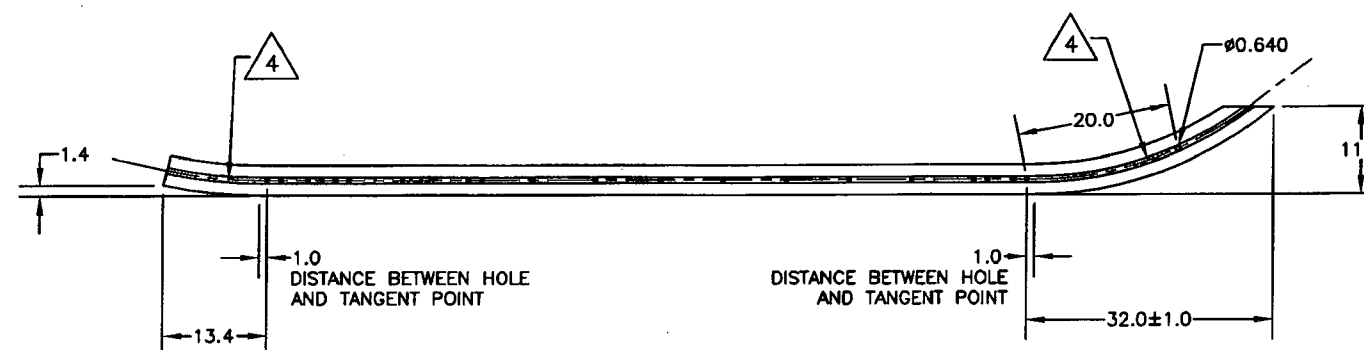
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

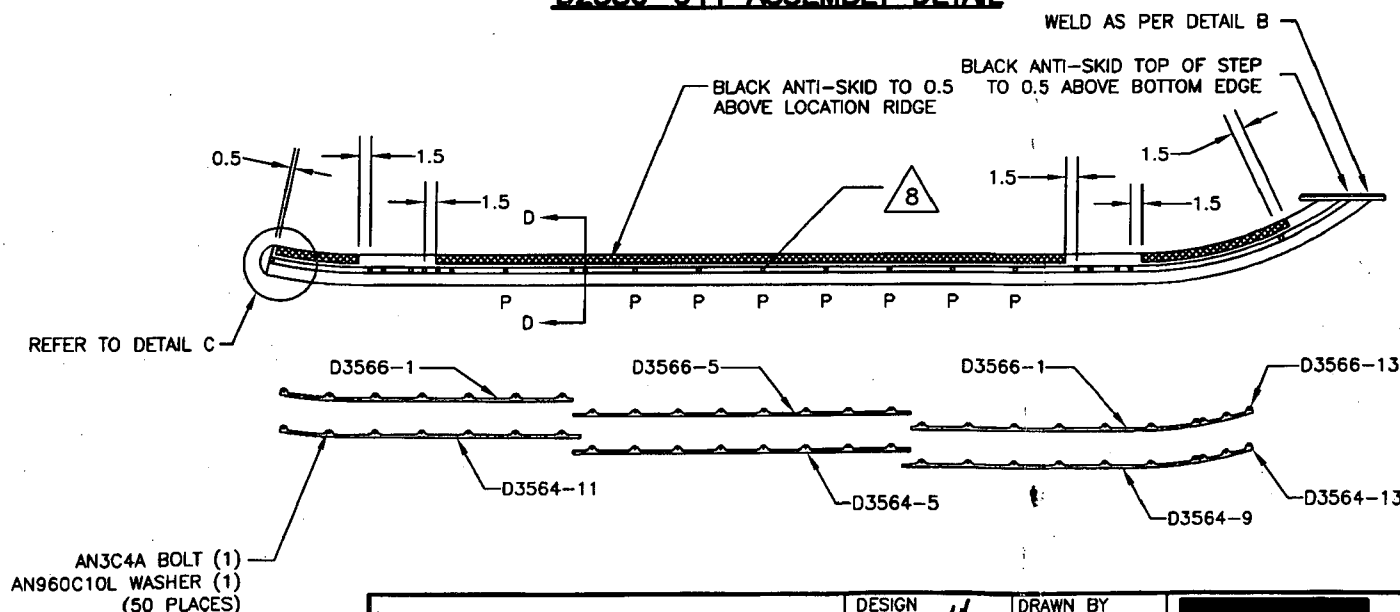
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

RELEASED
07 Dec 28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a propeller hub cross-section showing the installation of a D2855 cap. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two small circular holes in the hub.
- SEAL WITH SIKAFLEX-241/-291**: Points to the gap between the cap and the hub.
- AN3-5A BOLT (1)**: Points to a bolt securing the cap.
- AN960JD10L WASHER (1) (2 PLACES)**: Points to two washers used for the bolt.
- D2855 CAP**: Points to the cap being installed.
- SEE NOTE ii)**: Points to a specific area on the cap.
- 0.40**: Dimension indicating the thickness of the cap.
- Ø0.208**: Dimension indicating the diameter of the holes.

D2579 SPACER

WEB (REF)

AFTER PERFORM

1. CHA
2. INS
3. WEL

ALS7-1032-130 (REF)
(TYP 50 PLACES)

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750 1.750

Ø0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750 17.375 26.000 34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0 91.500 190.0
(D2500-1)

(MAKE FROM D2380-1 DRILLING DETAIL)

51.340
39.580
5.985
5.338 (REF)
3.630 (REF)
5.915
Ø0.508 (8 PLACES)
Ø0.640
20.0
11.5
1.4
4
1.0
DISTANCE BETWEEN HOLE AND TANGENT POINT
13.4
DISTANCE BETWEEN HOLE AND TANGENT POINT
1.0
32.0 ± 1.0

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205 SKIDTUBE ASSEMBLY

SCALE
1:24

